What is claimed is:

1. A continuous ceramic composite plating method for long doctor base materials comprising: a degreasing step; rinsing step; acid immersion step; rinsing step; electroless ceramic composite nickel plating step; plating solution collection step; rinsing step; and drying step between a first step of supplying continuously a long doctor blade base material held on a material reel spirally while the blade surface is maintained in a horizontal direction with respect to the surface of a solution and a final step of taking up continuously the blade base material on a corresponding take-up reel while the blade base material is cramped by a plurality of pinch rolls.

2. A continuous ceramic composite plating method for long doctor base materials comprising: a degreasing step; rinsing step; acid immersion step; rinsing step; electroless ceramic composite nickel plating step; plating solution collection step; rinsing step; and drying step between a first step of supplying continuously a plurality of long doctor blade base materials held on a plurality of material reels spirally while the blade surfaces are maintained in a horizontal direction with respect to the surface of a solution and a predetermined interval therebetween is maintained and a final step of taking up continuously the plurality of doctor blade base materials on a plurality of corresponding take-up reels while the plurality

of blade base materials are cramped by a plurality of pinch rolls.

3. The continuous ceramic composite plating method according to claim 1 or 2, wherein the doctor blade base materials are of a double-edged type, supplied from the material reels with a central portion other than both edge portions masked in a belt form, and taken up on take-up reels.

4. A continuous ceramic composite plating method for long doctor base materials comprising: letting out the long doctor base materials plated by the method according to any one of claims 1 to 3 from the take-up reels, straightening out and baking the long doctor base materials by passing through a heating furnace.

5. A continuous ceramic composite plating apparatus for long doctor base materials, including: one or a plurality of material reels for holding one or a plurality of long blade base materials spirally; a plurality of pinch rolls for cramping and forwardly supplying the one or plurality of blade base materials continuously while the blade surface(s) of the one or plurality of blade base materials are maintained in a horizontal direction with respect to the surface of a solution and a predetermined interval therebetween is maintained; and the same number of take-up reels for taking up the one or plurality of blades continuously, said apparatus comprising: a degreasing tank; rinsing tank; acid immersion tank; rinsing

tank; electroless ceramic composite nickel plating tank; plating solution collecting tank; rinsing tank; and drying tank between the material reels and the take-up reels.

6. The doctor blade plating apparatus according to claim 5, wherein a space tank is disposed between the respective treatment tanks, and a partition plate having a slit portion through which a single blade can pass or a plurality of parallel slit portions through which a plurality of blades can pass with maintaining a predetermined interval therebetween is used to separate each treatment tank from each space tank.

7. An apparatus for continuously producing baked long doctor materials comprising: a plurality of pinch rolls for continuously forwardly straightening out long doctor materials plated by the method according to claim 1 or 2 from the take-up reel; and a straightening furnace for baking through which the straightened plated blades pass.